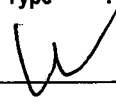
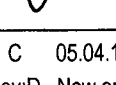


Date: Thursday, 29/03/2007 2:26:15 PM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : BASE PLATE PANEL
<b>Job Number</b> : 31522	
<b>Estimate Number</b> : 11213	
<b>P.O. Number</b> : N/A	<b>Part Number</b> : D33331
<b>This Issue</b> : 29/03/2007 <b>S.O. No.</b> : N/A	<b>Drawing Number</b> : D3333 REV 5
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : N/A	<b>Drawing Revision</b> : N/A
<b>Previous Run</b> : 31522	<b>Material</b> : N/A
<b>Written By</b> : 	<b>Due Date</b> : 08/04/2007
<b>Checked &amp; Approved By</b> : 	<b>Qty:</b> 20 <b>Um:</b> Each
<b>Comment</b> : Est: C 05.04.15 Made in-house KJ/JLM Est Rev:D Now on Waterjet 07-03-29 JLM	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
----------------	------------------------------	----------------------

1.0	M4140NB0625X04000	AISI 4140 Steel Bar
-----	-------------------	---------------------



**Comment:** Qty.: 0.7984 f(s)/Unit Total : 15.9684 f(s)  
 AISI 4140 Steel Bar  
 Material: AISI 4140 Steel Minimum yield tensile strength: 100ksi  
 (M4140N-B0.625x04.000)  
 Identify for D3333-1  
 Batch: m104481

ml 07 06 17

(20)

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



**Comment:** FLOW WATER JET  
 1-Cut as per Dwg D3333  
 Dwg Rev: B  
 Prog Rev: B

ml 07 06 18

(20)

(P+0) →

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

ml 07 06 18

(20)

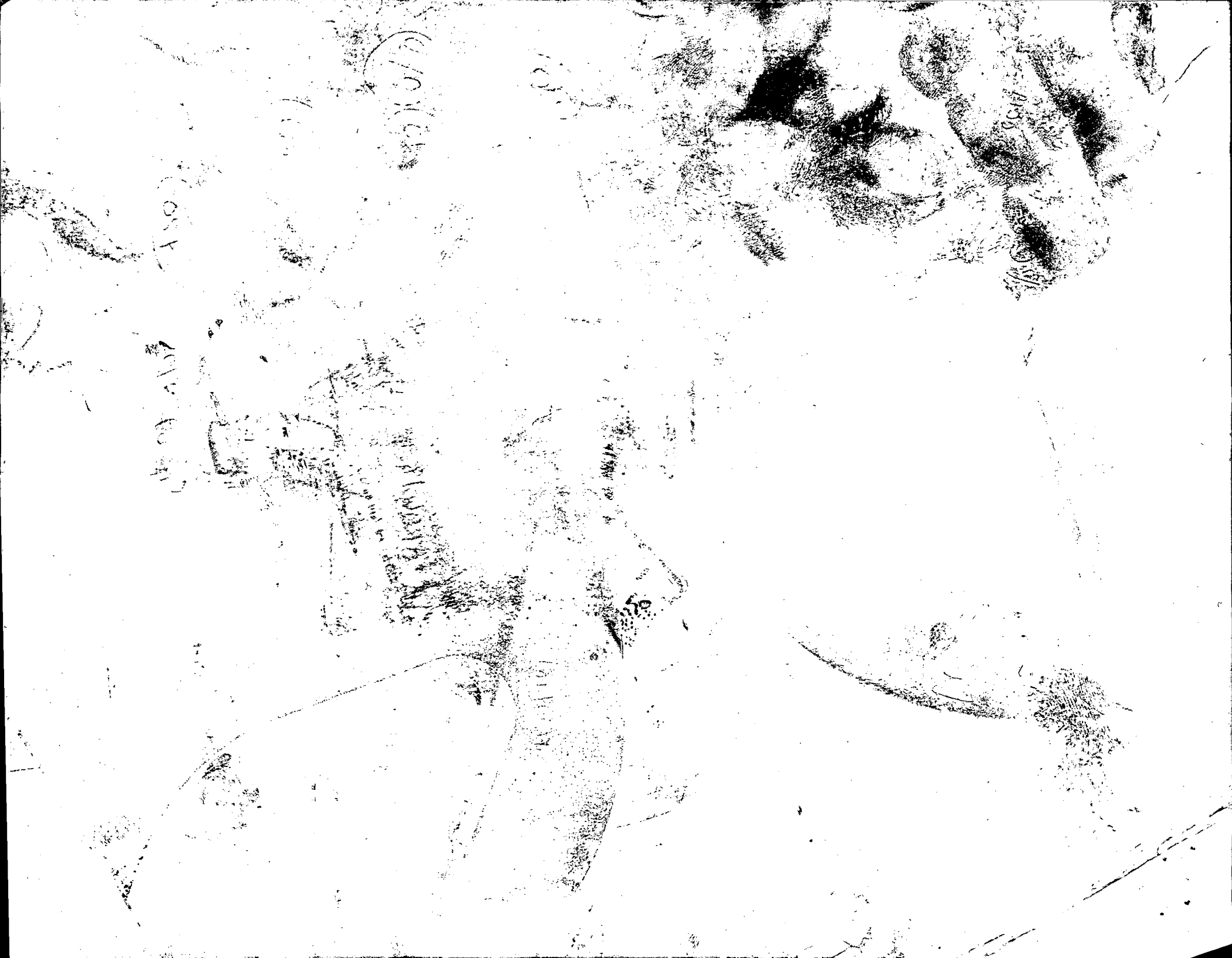
4.0	QC8	SECOND CHECK
-----	-----	--------------



**Comment:** SECOND CHECK

Er 07/07/25

(20)



Date: Thursday, 29/03/2007 2:26:15 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASE PLATE PANEL

Job Number: 31522

Part Number: D33331

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Open hole to .201" then tap 1/4"-20nc as per Dwg D3333

*07/07/26*

*(20)*

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*En 07/07/26 + 20*

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Deburr

*07/07/31 (20)*

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3  
Mask threaded holes.

*M18052*

*(20X)*

*07/08/07*

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*07/8/8 (20)*

*7*

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

*57488 07/8/8 (20)*

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*07/08/09*



Job Completion



*07/08/09*

Date: Wednesday, 28/03/2007 9:16:16 AM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : BASE PLATE PANEL
<b>Job Number</b> : 31522	
<b>Estimate Number</b> : 11213	
<b>P.O. Number</b> :	<b>Part Number</b> : D33331
<b>This Issue</b> : 28/03/2007 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3333 REV B
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : LARGE FAB ASSY	<b>Drawing Revision</b> : B
<b>Previous Run</b> : 28615	<b>Material</b> :
<b>Written By</b> : 	<b>Due Date</b> : 04/04/2007 <b>Qty:</b> 20 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : 	
<b>Comment</b> : Est. C 05.04.15 Made in-house KJ/JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M4140N-B0.750x04000 625	AISI 4140 Steel Bar
-----	-------------------------	---------------------



**Comment:** Qty.: 0.7984 f(s)/Unit Total: 15.9684 f(s)  
 AISI 4140 Steel Bar  
 Material: AISI 4140 Steel Minimum yield tensile strength: 100ksi  
 (M4140N-B0.750x04.000)  
 Identify for D3333-1  
 Batch: \_\_\_\_\_

2.0	BAND SAW	BAND SAW
-----	----------	----------



**Comment:** BAND SAW  
 Cut blanks: 9.00" x 4.00" x 0.750" thick

3.0	HAAS WATERLOO	HAAS CNC VERTICAL MACHINING #1
-----	---------------	--------------------------------



**Comment:** HAAS CNC VERTICAL MACHINING #1  
 Machine as per Folio FA478 and Dwg D3333  
 Tap as per Dwg D3333  
 Identify as D3333-1

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

5.0	QC8	SECOND CHECK
-----	-----	--------------



**Comment:** SECOND CHECK

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/06/18	# 20	two (2) extra holes p. 201 were cut <del>and</del> in all 20 parts.  Root Cause: Program is wrong and Draw. need to be updated	<i>MP</i>	Parts are acceptable  change Program	<i>MP</i>  07.06.18	<i>So</i> 07/07/18	<i>MP</i>	<i>En</i> 07/07/18

NOTE: Date & initial all entries

Date: Wednesday, 28/03/2007 9:16:17 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASE PLATE PANEL

Job Number: 31522

Part Number: D33331

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1  
Deburr

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING  
Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3  
Mask threaded holes.

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Identify and Stock  
Location: \_\_\_\_\_

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

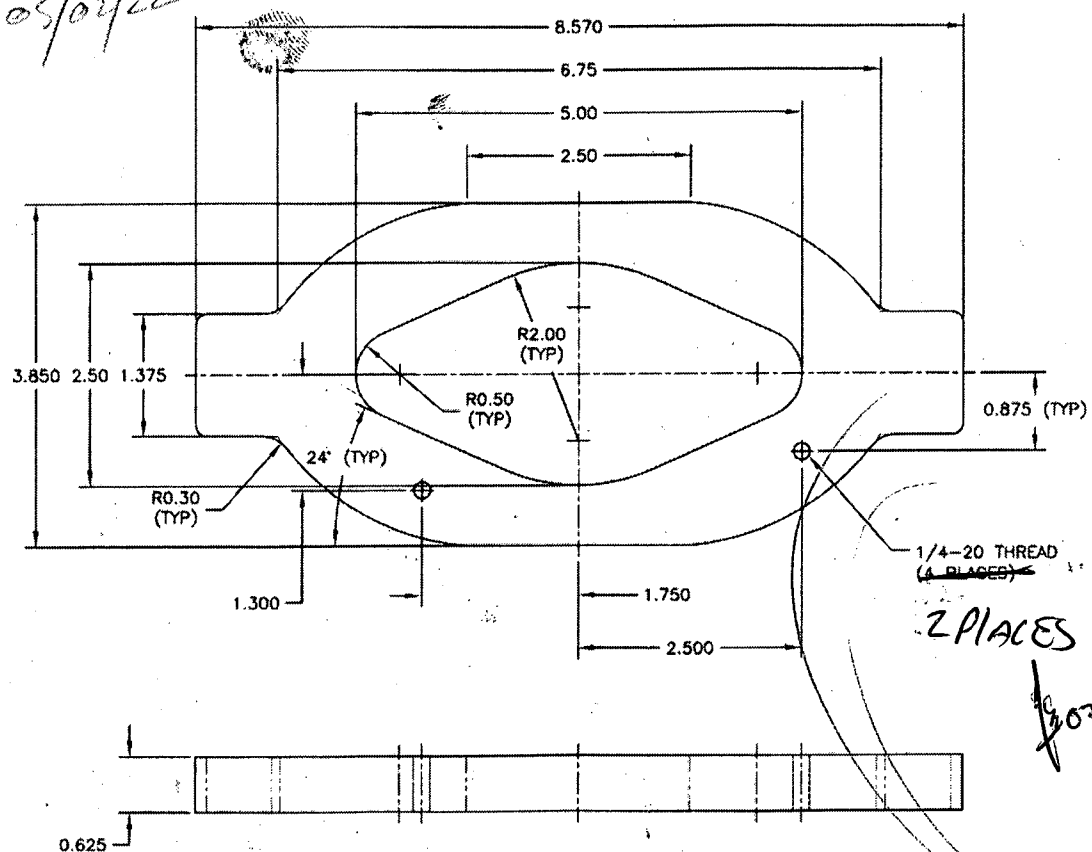
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN H	DRAWN BY H	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 3	APPROVED H	DRAWING NO. D3333	REV. B SHEET 1 OF 3
DATE 05.02.18	TITLE PLATE	SCALE 1:2	
A	04.12.14	NEW ISSUE	
B	05.02.18	RE-DESIGN D3333-3	

RELEASED  
05/02/22



### D3333-1 BASE PLATE PANEL

#### NOTES:

- 1) MATERIAL: AISI 4140 STEEL 0.625 THICK STEEL (REF. DART SPEC. M4140-B)  
MIN. YIELD TENSILE STRENGTH = 100 ksi
- 2) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

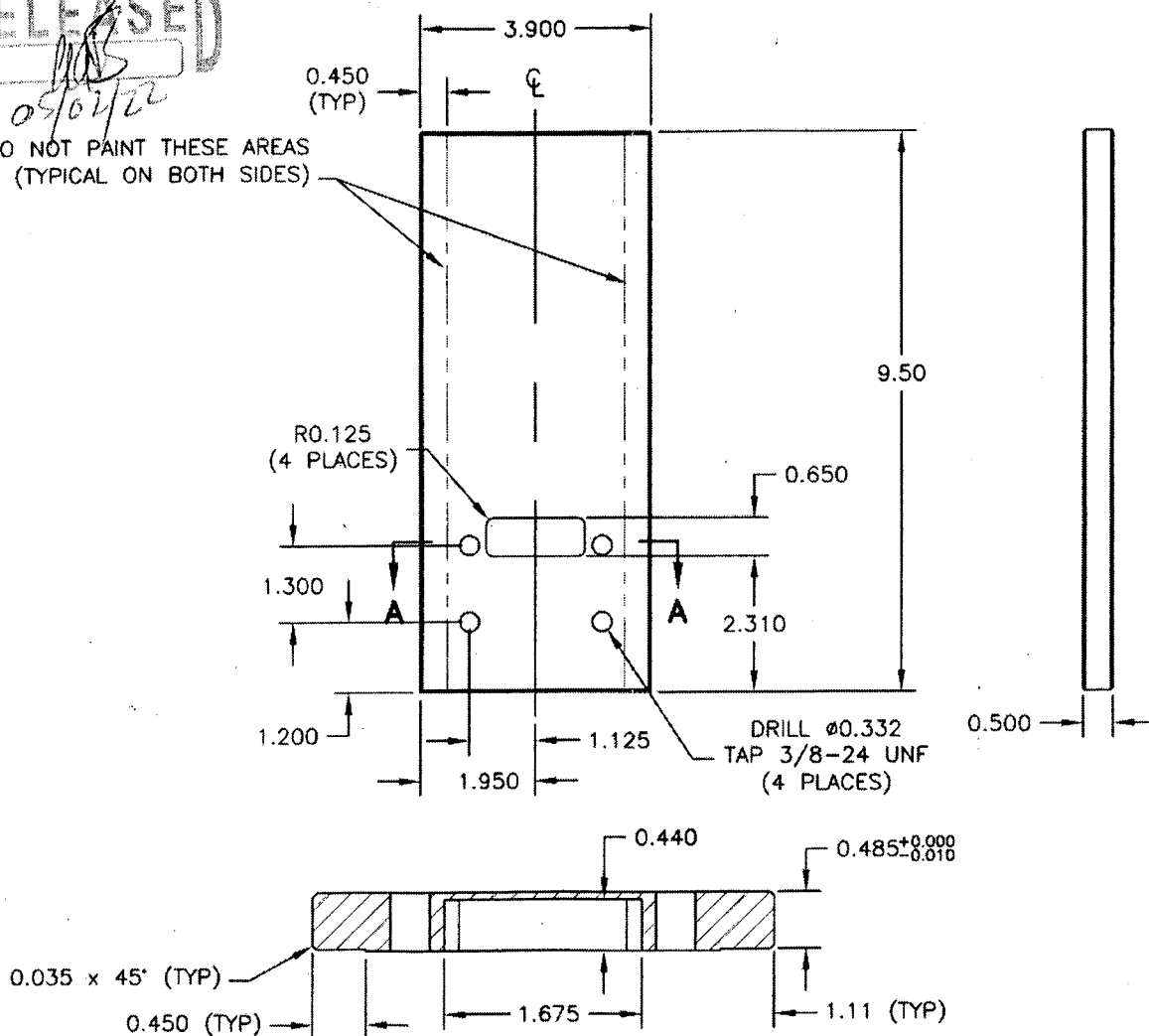
**NOTE:** Date & initial all entries



DESIGN H	DRAWN BY H	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED B	APPROVED [Signature]	DRAWING NO. D3333	REV. B SHEET 2 OF 3
DATE 05.02.18	TITLE PLATE		SCALE 1:4

RELEASED  
05/02/18

DO NOT PAINT THESE AREAS  
(TYPICAL ON BOTH SIDES)



SECTION A-A

### D3333-3 SLIDING PLATE

#### NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570, 0.50 THICK MILD STEEL (REF. DART SPEC. M1010-B)
- 2) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

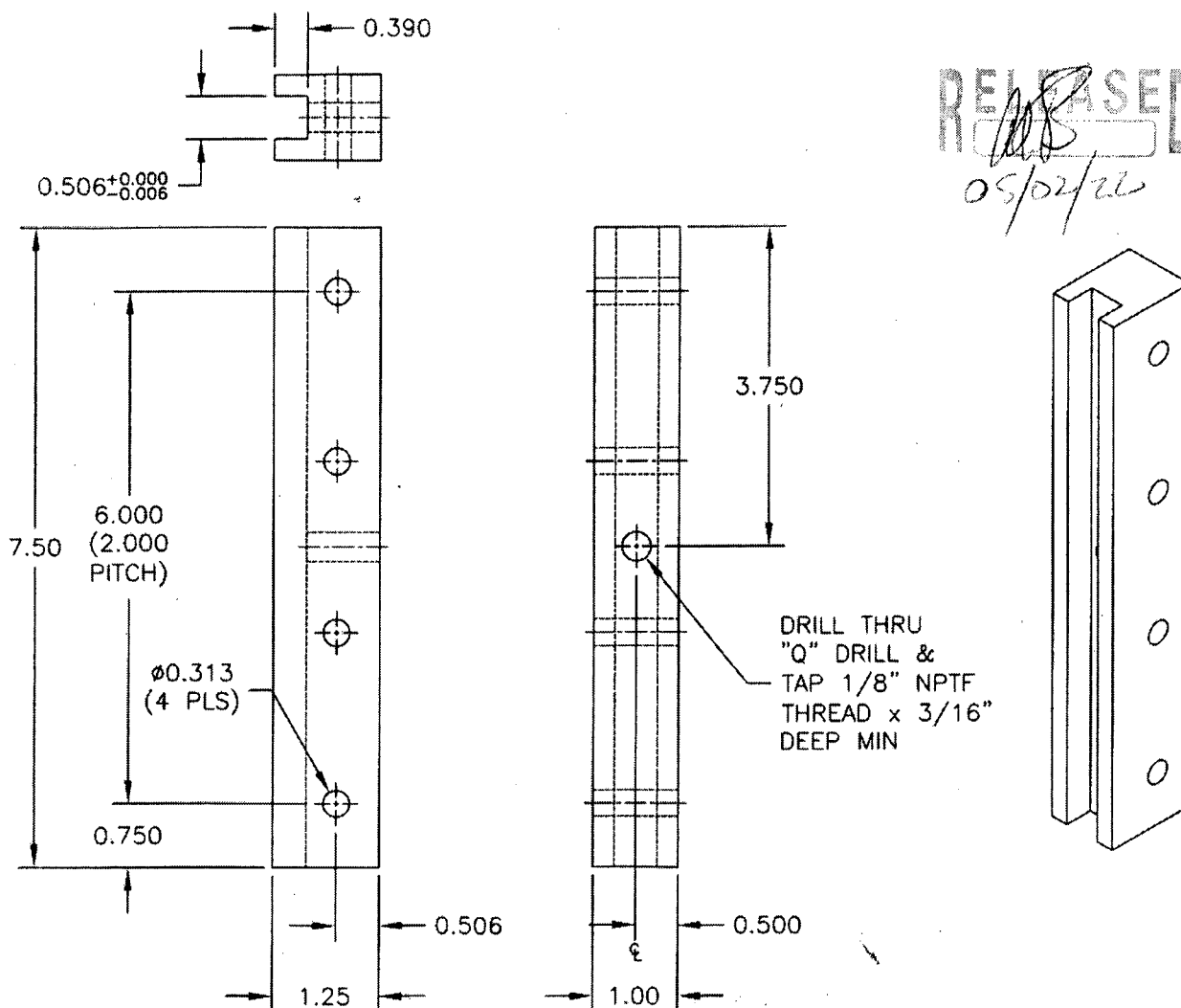
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3333	REV. B SHEET 3 OF 3
DATE 05.02.18		TITLE PLATE	SCALE 1:2



### D3333-5 RAIL

#### NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570, 1.00 THICK STEEL (REF. DART SPEC. M1010-B)
- 2) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DAKT AEROSPACE LTD		Work Order: 31522
Description: BASE Plate Panel		Part Number: D3333-1
Inspection Dwg: D3333 Rev: B		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 0.625	+/-0.010	0.620	✓		VERN	
B 8.510	+/-0.010	8.513	✓		VERN	
C 3.850	+/-0.010	3.860	✓		VERN	
D 1.375	+/-0.010	1.375	✓		VERN	
E 2.50	+/-0.030	2.50	✓		VERN	
F 5.00	+/-0.030	5.00	✓		VERN	
G 6.75	+/-0.030	6.75	✓		VERN	
H 2.50	+/-0.030	2.50	✓		VERN	
I 1/4 x 20	Ref	1/4 x 20	—			
J						
K						
L						
M						
N						
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by: <i>MW. MW</i>	Audited by: <i>En</i>	Prototype Approval:	N/A
Date: 07 06 18	Date: 07 06 19	Date:	N/A

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	

